

Work Order ID 63578

Thursday, November 04, 2010 1:08:27 PM



Page 1

Item ID: D3536-39

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 11/4/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/11/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

10-11-16

(20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-11-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/11/16

counted
722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63578

Thursday, November 04, 2010 1:08:27 PM

Page 2

Item ID: D3536-39

Accept

Setup Start

Revision ID:

Step

Item Name: Gasket

Start Date: 11/4/2010 Start Qty: 16.00

Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 16.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *HP 12*

0.00



Packaging

Memo

0.00

Packaging

10/11/17

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/17
PS 10-11-17
(22)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:08:32 PM

Page 1

Work Order ID: 63578

Parent Item: D3536-39

Parent Item Name: Gasket



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	495.6220	0.7534	13.39378	8		
NEOPRENE SHEET 0.063													

B10-11-16

Location

Loc Qty

Loc Code

MAT

495.622

115500

95.622

115916

400

115916

22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63578
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	h		T B01	
32.78	+/-0.030	32.78	h		T	
29.28	+/-0.030	29.28	h		T	
25.78	+/-0.030	25.78	h		T	
23.25	+/-0.030	23.25	h		T	
19.75	+/-0.030	19.75	h		T	
17.75	+/-0.030	17.75	h		T	
14.25	+/-0.030	14.25	h		T	
9.50	+/-0.030	9.50	h		T	
4.75	+/-0.030	4.75	h		T	
5.00	+/-0.030	5.00	h		T	
9.00	+/-0.030	9.00	h		T	
0.30	+/-0.030	.296	h		V B02	
0.30	+/-0.030	.292	h		V	
1.88	+/-0.030	1.887	h		V	
Ø0.19	+0.005/-0.001	.191	h		V	
0.063	+/-0.010	.063	h		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-11-16	Date: 10/14/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

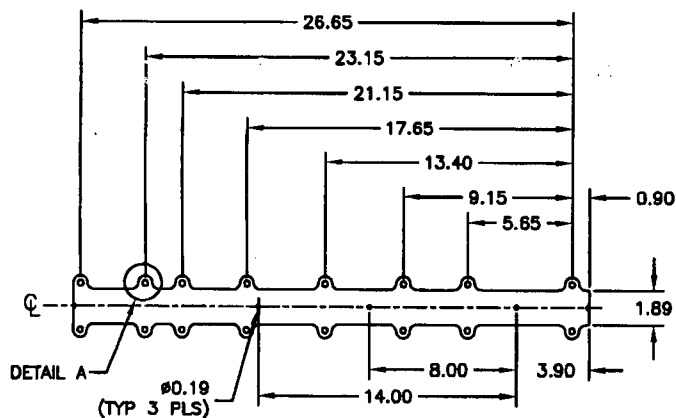
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NOTE: Date & initial all entries

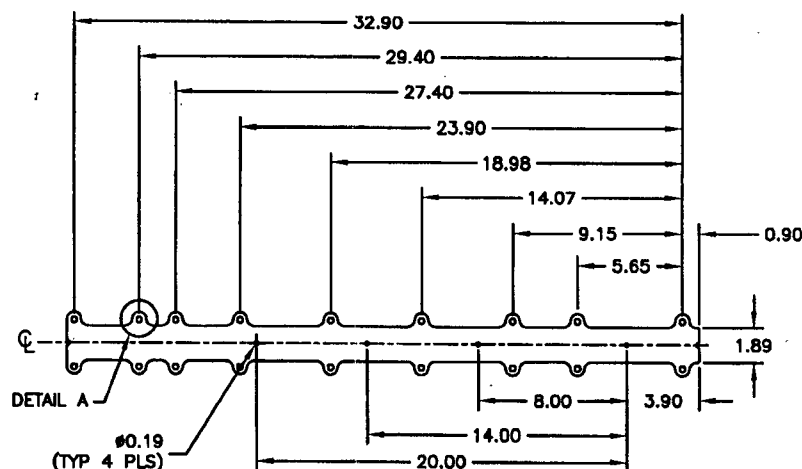
DART

RELEASED
09-02-12-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43578
10-11-04



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	PH	D3536	SHEET 1 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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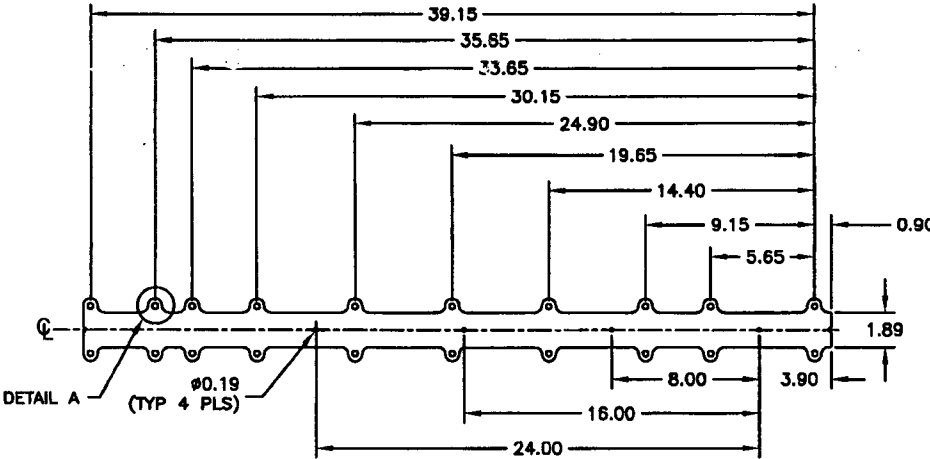
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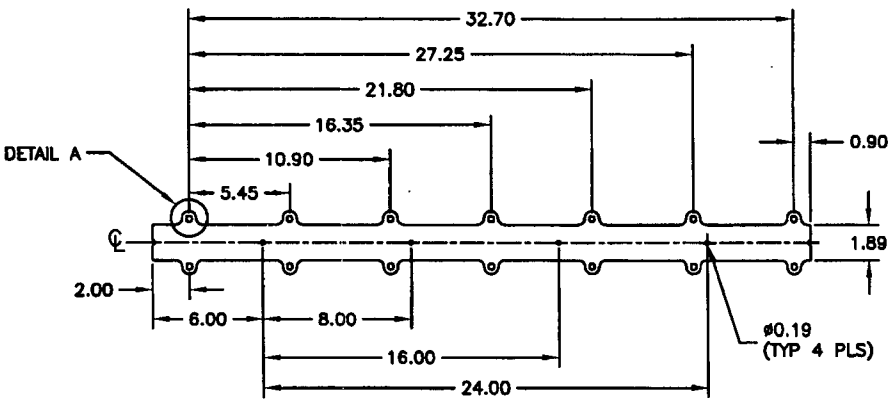
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

PREPARED
07.02.12

WLC 43578



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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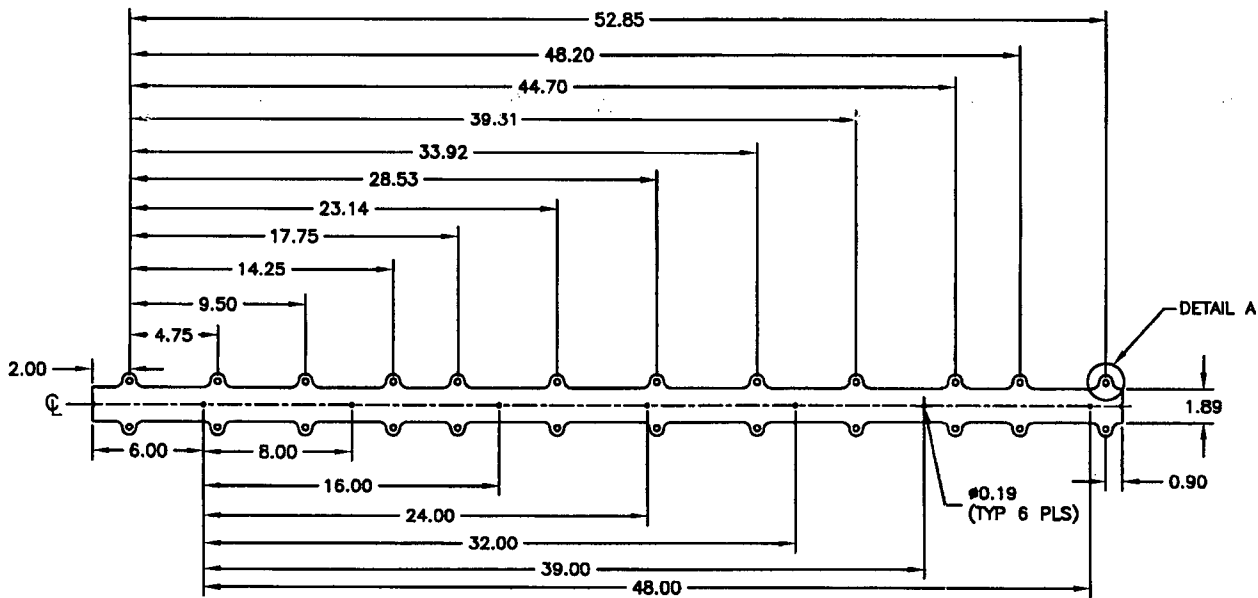
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DART

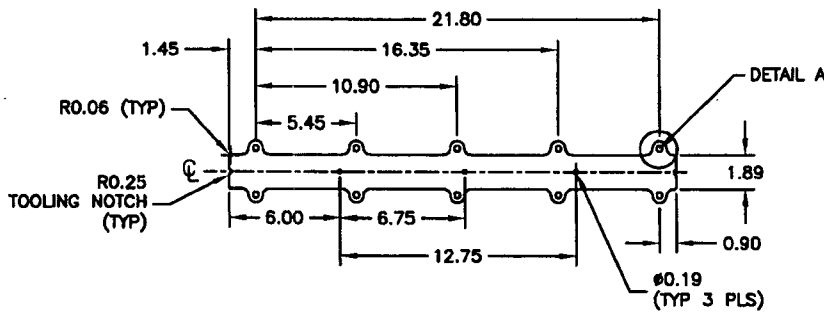
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 3 OF 6
				SCALE 1:10

07.02.12
PH



D3536-23 GASKET

u/o 43578



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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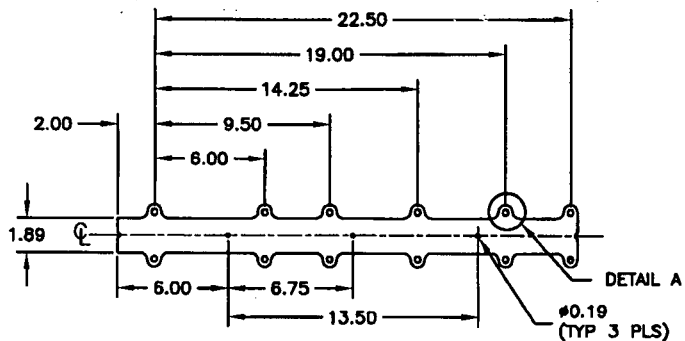
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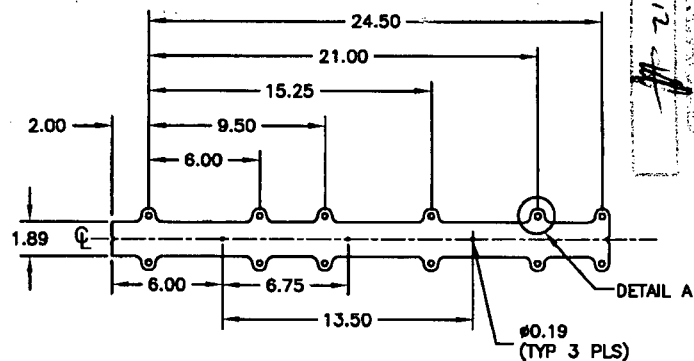
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
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				SCALE 1:10

07.02.12
#1

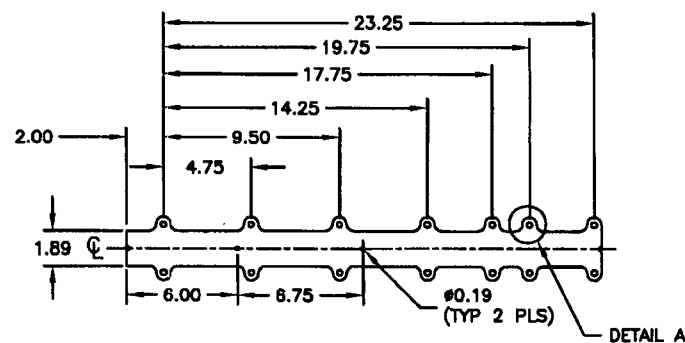


D3536-31 GASKET



D3536-33 GASKET

wk 43578



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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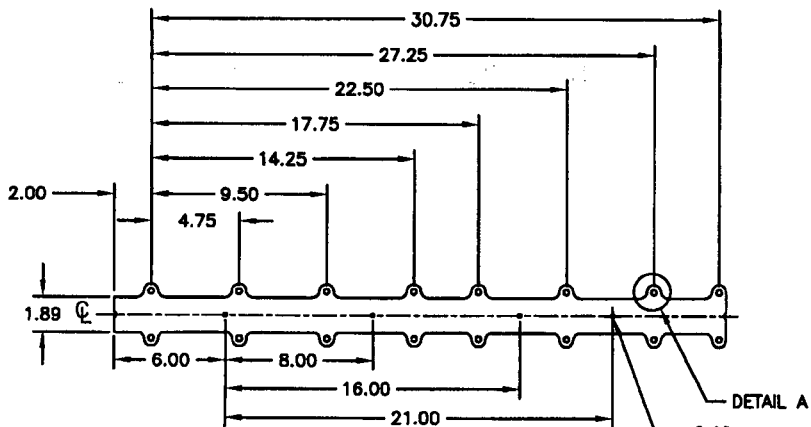
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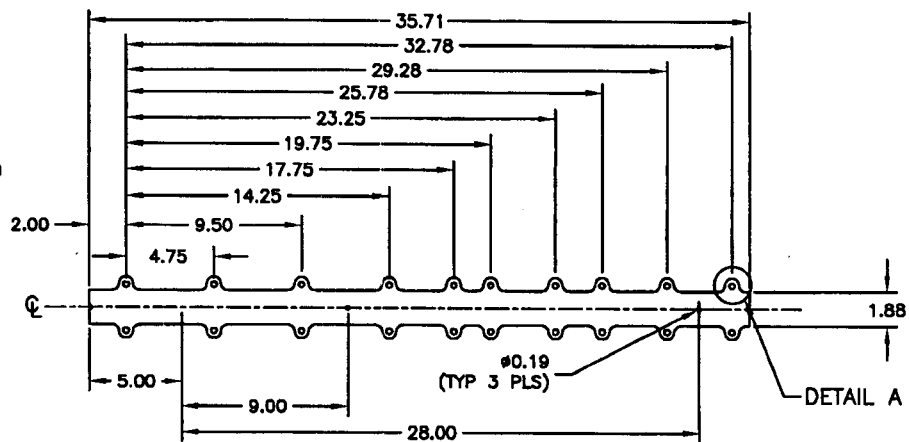
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DATE	06.10.25	TITLE	D3536	GASKET	SHEET 5 OF 6
		SCALE	1:10		

07.02.02 CH

w/o 43578



D3536-37 GASKET



D3538-39 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
 - 2) FINISH: NONE
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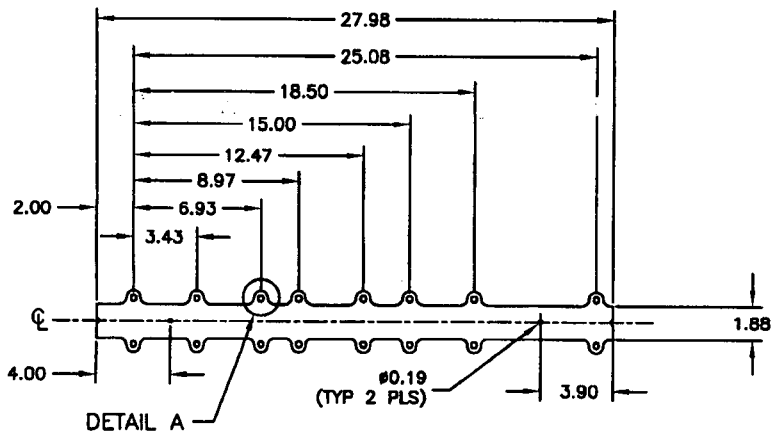
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DART

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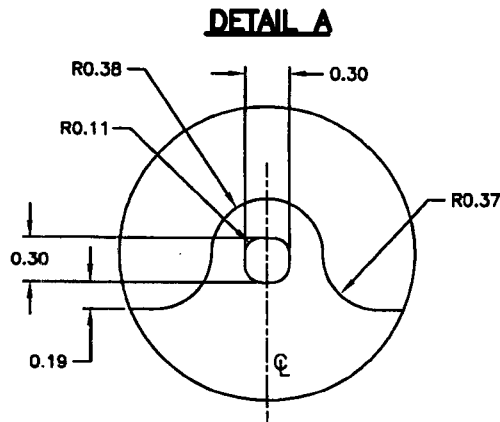
wb 63578




D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A
CHECKED PH	APPROVED 	DRAWING NO. D3536	SHEET 6 OF 6	
DATE 06.10.25	TITLE GASKET		SCALE	1:10

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